

Date: Thursday, 14/05/2009 11:13:14 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 47961 -2
 Estimate Number : 10707
 P.O. Number :
 This Issue : 14/05/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL /MED FAB
 Previous Run : 47665

Drawing Name : ARM

Part Number : D2012105
 Drawing Number : D2012-105 U/R
 Project Number : N/A
 Drawing Revision : D1
 Material :
 Due Date : 21/05/2009

Qty: 10 Um: Each

Written By :
 Checked & Approved By : MF 09-05-14
 Comment : Est Rev:1 02.04.03 Added Inspect level 3 NG

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0500W035 304 RD Tube .500 x .035W



Comment: Qty.: 2.7567 f(s)/Unit Total: 27.5667 f(s) 22.0536
 Material: 304/316 Seamless SS tubing, 1/2" O.D. x .035" wall(M304TR0.500W.035)
 Identify as D2012-101
 Batch: 1111704

FF 09-05-20

(8)

2.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Punch to length as per Dwg D2012-105 & template D2012-105T1

FF 09-05-20

(8)

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

FF 09-05-20

(8)

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

D2012/5/20 (x8)

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

11:00
320

MD 09/05/20

(x8)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 14/05/2009 11:13:14 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 47961

Part Number: D2012105

Job Number:



Seq. #:

Machine Or Operation:

Description :

FINISH TIME:

11:30

MD

09/05/20

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



el



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-20

(X5)
(8X)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 229

9/5/21

54

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-21

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2012-105	REV. D SHEET 1 OF 1
DATE 98.04.28		TITLE ARM	SCALE NTS
A	92.06.04	NEW ISSUE - DRAWN FROM D2012	
B	96.06.25	30° ANGLE ROTATED 60° CCW	
C	97.09.03	CORRECTED VIEWS PER TSR A374	
D	98.04.28	ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD	
DI	<i>42</i> 02.03.25	ADD FINISH	

RELEASED
98/05/05 KE



31.86 Total length

#47961

NOTES:

1. MAKE PER TEMPLATE DT8116 (WAS D2012-105)
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.500 \times 0.035$ WALL
- 3 FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART. Q51.005 4.3 *DA*